

11/09

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:55:36 AM  
 User: Chantal Lavoie

## Process Sheet

Customer : N/A	Drawing Name : STIFFNER
Job Number : 34540	
Estimate Number : 12957	
P.O. Number : N/A	Part Number : D36393
This Issue : 9/11/2007	Drawing Number : D3639 UNDER REVIEW
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : U/R
First Issue : N/A	Material : N/A
Type : SMALL / MED FAB	Due Date : 9/18/2007
Previous Run : N/A	Qty: 10 Um: Each
Written By : <u>W</u>	
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By: EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.4491 sf(s)/Unit Total: 4.4909 sf(s)  
 2024-T3 .050 sheet  
 Batch: ~~W07-09-19~~ 1105646  
IB 07-09-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as-per Dwg D3639  
 Dwg Rev: PREL  
 Prog Rev: PREL

IB 07-09-192-Deburr if necessary IB 07-09-19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
IB 07-09-19

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK  
E 2/09/19 (x10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
C-sink as per Dwg D3639

N/A 2/09/19 07-09-20



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/12	4 2.0	10 parts scrap. wrong Program was used (Preliminary not new DPA) causing the location of the 0.625" and 0.191" holes to be off by 0.100"	<i>[Signature]</i> 07/04/12	Scrap and destroy and Replace All parts	<i>[Signature]</i> 07-08-12	En 07/09/12	<i>[Signature]</i> 07/09/12	En 07/09/12
		R.C. wrong Program was used and Human/operator error (water Jet)	<i>[Signature]</i> 07/04/12	Remove wrong Programs from the net work	<i>[Signature]</i> 07-04-12	En 07/04/12	<i>[Signature]</i> 07/04/12	En 07/04/12

NOTE: Date & initial all entries



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Drawing Name: STIFFNER

Job Number: 34540

Part Number: D36393

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

SB 07/09/20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 02/09/20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 07/09/20 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 02/09/20 (10) counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

UE 07.10.15  
ENGINEERING  
APPROVAL  
7/10/15 Sd (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7 07/10/22 (10)

Job Completion



POSITIVE RECALL

RECEIVED 07/10/15 AUTH UE  
DATE 07/10/15 DATE UE

U 07.10.16



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

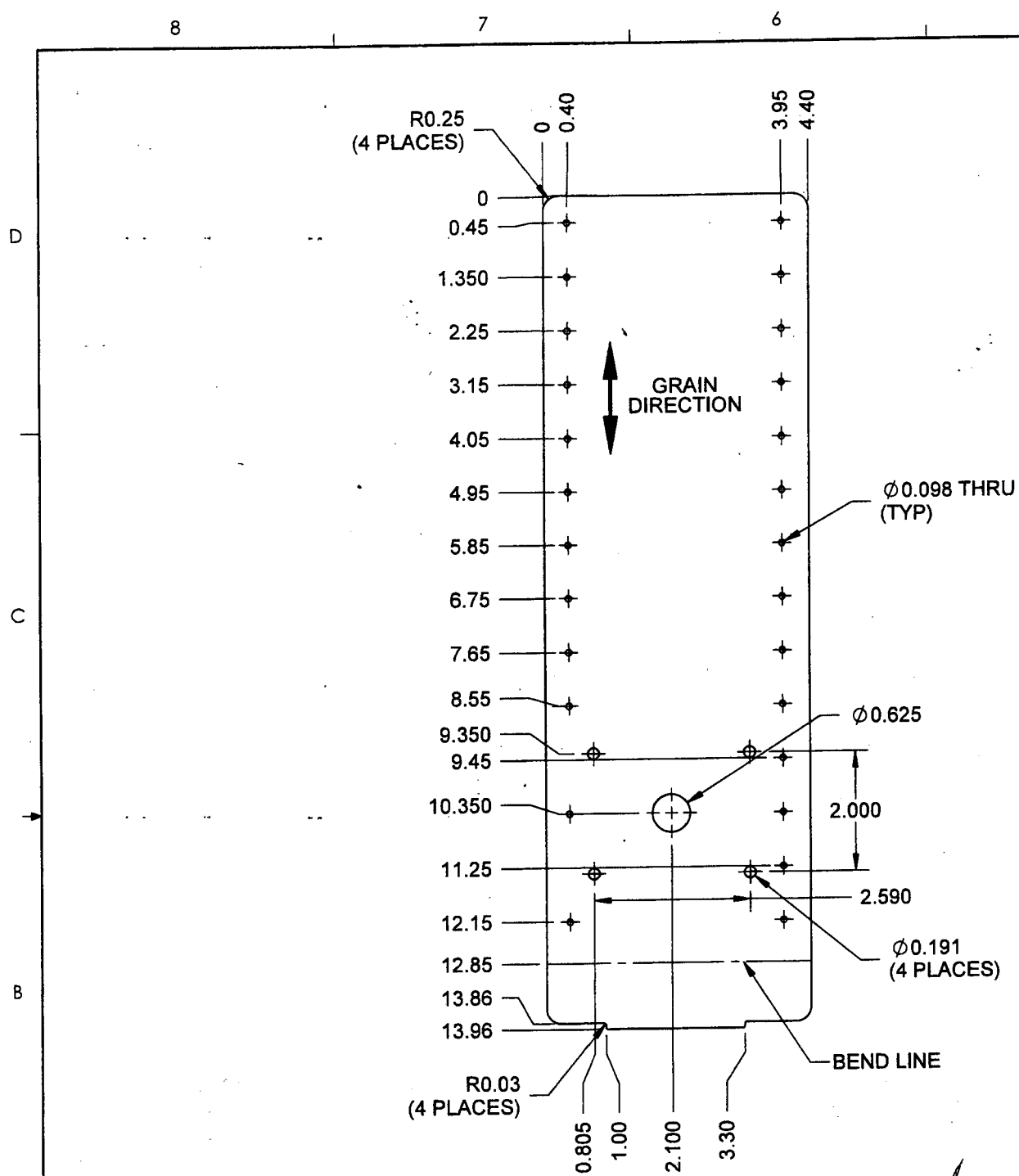
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries





**D3639-3F FLAT PATTERN**  
**(D3639-4F OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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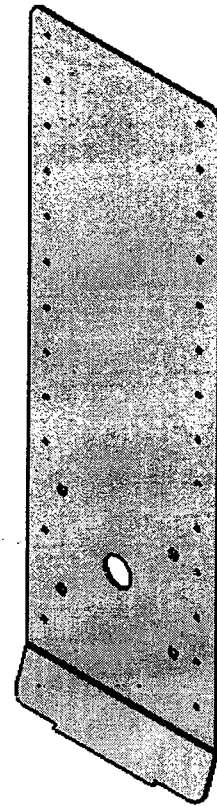
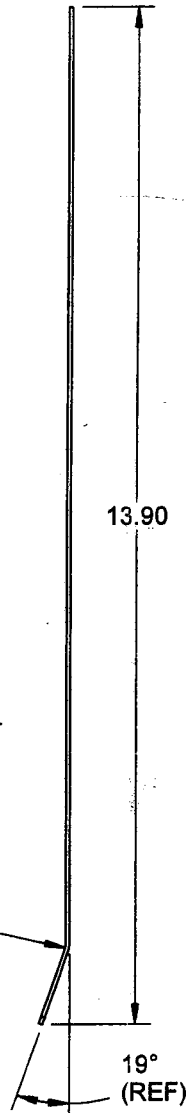
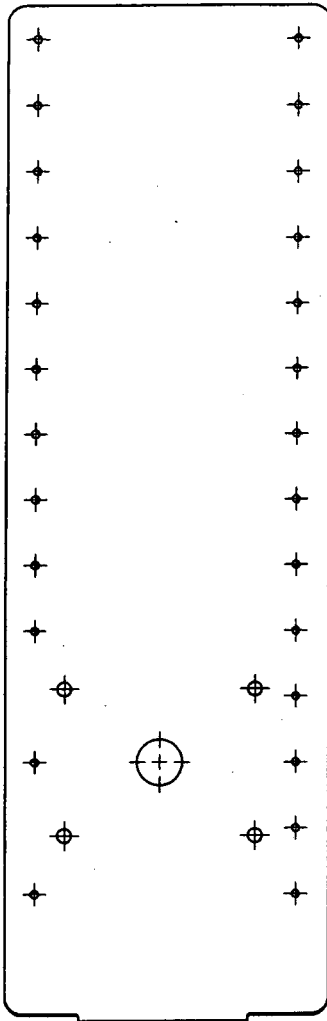
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3639-3 DOUBLER**  
**(WAS GENEVA P/N G10604-4)**  
**D3639-4 OPPOSITE**  
**(WAS GENEVA P/N G10604-5)**

**PRELIMINARY ISSUE**

07.09.07

DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	CE		
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 2 OF 2
APPROVED	WP	TITLE	SCALE
DE APPR.		DOUBLER	2:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**Dart Aerospace Ltd**

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